

Date:
User:Monday, 4/10/2006 11:13:52 AM
Kim Johnston

Process Sheet

split SP 06/05/16

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26612
 Estimate Number : 12308
 P.O. Number : NIA
 This Issue : 4/10/2006 S.O. No. : NIA
 Prsht Rev. : NC
 First Issue : NIA Type : SMALL / MED FAB
 Previous Run : 26462
 Written By : See comment Below
 Checked & Approved By :
 Comment : est rev A 06.03.02 New issue EC

Drawing Name : BLOWER MOTOR SUPPORT

Part Number : D34711
 Drawing Number : D3471 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material : NIA
 Due Date : 4/28/2006

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 1042

Email or Ship DXF file to vendor

Cut per Dwg D3471 flat pattern D3471-1F

possible supplier: GFI

Material release note required

C 206/04/28

2.0 D34711F BASE FLAT PATTERN



Comment: Qty.: 1.0000 sf(s)/Unit Total : 1.0000 sf(s)
 SUPPORT FLAT PATTERN

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

AB 06/04/28

(12)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3471

D-05-02 12

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1




1-Deburr

2-Bend as per dwg D3471

DSB 06/04/2010

H-M 06/05/03 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-06-21	5.1 ↓ ▽	QC S. Inspect work	J	06-06-21	100			
06-06-21	5.1 ↓ 6.0	Add QCS before Abcline i have QB After Abcline permanent change. J						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 17 Date: 06/06/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/06/20	5	1 piece was out of tolerance		Scrap + destroy	SB 06/06/21			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26612

Part Number: D34711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M

06-06-27

(9)

7.0

QC5

INSPECT WORK TO CURRENT STEP

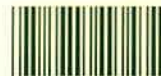


Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Identify more fine marks

Location:

ST 356

Ref/29 (9)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 106/30 (9)

Job Completion



W 06-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

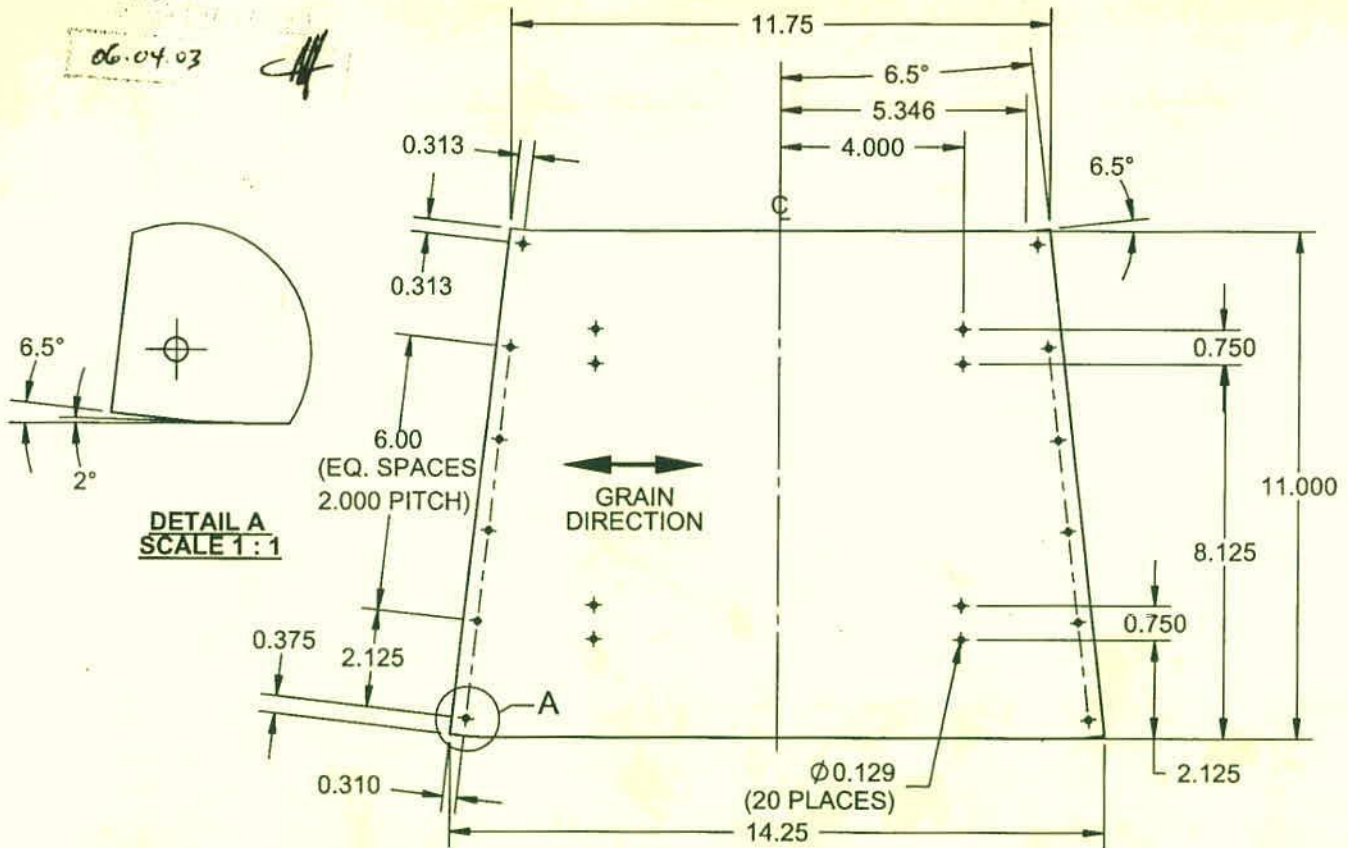
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

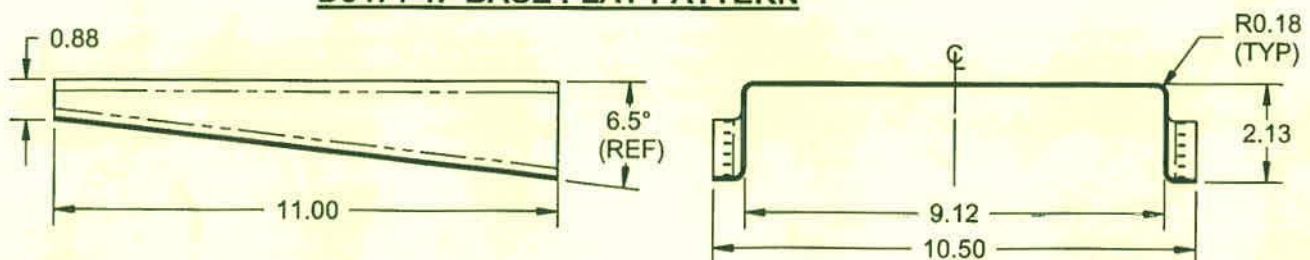
NOTE: Date & initial all entries

DART

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3471	REV. A SHEET 3 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:4



D3471-1F BASE FLAT PATTERN



D3471-1 BASE BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **26612**

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Linda Lacelle

From: Jeff Mostat [jeff@industriallaser.com]
Sent: Tuesday, May 02, 2006 2:39 PM
To: Linda Lacelle
Subject: Re: certs



24ga 304 ss.pdf

Hi Linda,

You guys should have the certs for D3471-1, as it was cut from the material Dart purchased from Copper&Brass a couple of months back. (0.063 2024 t3 alum.)

Jeff Mostat
Production Mgr.

Industrial Laser Cutting

ph.(604) 946-4152 ext.224
fax(604) 946-4153

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>
To: "Jeff Mostat (E-mail)" <jeff@industriallaser.com>
Sent: Tuesday, May 02, 2006 7:55 AM
Subject: certs

>
> Need certs asap for P.O 1042-
> D3467-1
> D3471-1
>
> thx
> LL
>

A large, stylized handwritten signature in blue ink, appearing to be 'LL' or similar initials.

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

525383
Ship Date

2005-11-07

306094
B.L. No.

87255

Invoice No.

42246

Alcoa No. Item

DS-90097-1

Page 1

P.O. No./Govt Contract No.

CG1887

Customer

C&B-WHS-SCHAUMBERG

Ship To: COPPER & BRASS SALES, INC.
415 STATE PARKWAY
SCHAUMBURG, IL 60195

Item Description

.0630 IN TK X 48.000 IN W X 144.000 IN LN CAT D 126153 (N) A/T 2024-T3 FLAT SHEET MILL FINISH {{ P/N 061847-0 }}. PER AMS-QQ-A-250/4 REV A & (EXCEPT OIL & MARKING) AMS4037 REV N & (EXCEPT MARKING) ASTMB209 REV 04 ((MARKED)) INTERLEAVED SKID WGT: 4500 LB QUAN TOL +/-10 % CQR D126153 REV 28 QRR 003140 CUST REQ 05-11-06 *** W/E 05-11-12 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	306626	481111	3851	90	PC	

Notes for CQR: D126153.28

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 2. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

CQR: D126153.28 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
T3	Long Transv.	KSI	KSI	PCT
	Max			
	Min	63.0	42.0	15

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other	
									Each	Total Aluminum	
	Max	.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15
Alloy 2024	Min			3.8	.30	1.2					REMAIN

Lot: 481111 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No.	UTS	TYS	EL4D
T3	Long Transv.	Test	KSI	KSI	PCT
	Max	6	68.4	45.5	20.5
	Min		67.5	44.9	17.5

1801042

0605-02

Paul 06

